			100							
	r ID 62711 - ber 06, 2010 3:39:28		1							Page I
Revision ID: tem Name:		Qty: \\ \frac{10.00}{0.00}		Accept	Cust Item II Customer:			Setup Star Stop	1100000000	
Approvals:	Process Plan: QC:	M	Date: Of C	O-Cly Tooling: SPC (Y/N):	THE REPORT OF THE STATE OF	nte:		Run Star Sto	I HE HILL ST	
Sequence ID/ Work Center ID	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool# Pla Coo	Control of the Contro	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r			1.124					
D4154	Α									
Large Fab		2059 B Har	-1, fill cut outs w		lwg D4154		E	10	-12-2	2 81

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154 304 S.S. Welding Rod BATCH #: /// 10/744

3-Transfer drill holes in bar

QC9- Inspect visual per QSI004- Fusion Welds 110 0.00

Memo

Quality Control



Work Order ID 62711

Wednesday, October 06, 2010 3:39:28 PM



Item ID: D4154-041

Accept

Setup Start

Revision ID:

Wearplate Assembly Item Name:

QC:

Start Date:

10/6/2010

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID: Customer:

Required Date: 10/15/2010

Reference:

Process Plan:

Date:

Tooling:

0.00

0.00

Date:

Tool#

Start

Stop



Approvals:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID



Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

scolin 123

Tool ID

Plan Code Qty

Accept Reject Qty

Run

Reject Number

Insp. Stamp

Quality Control

130



Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

Bh 10-12-23.

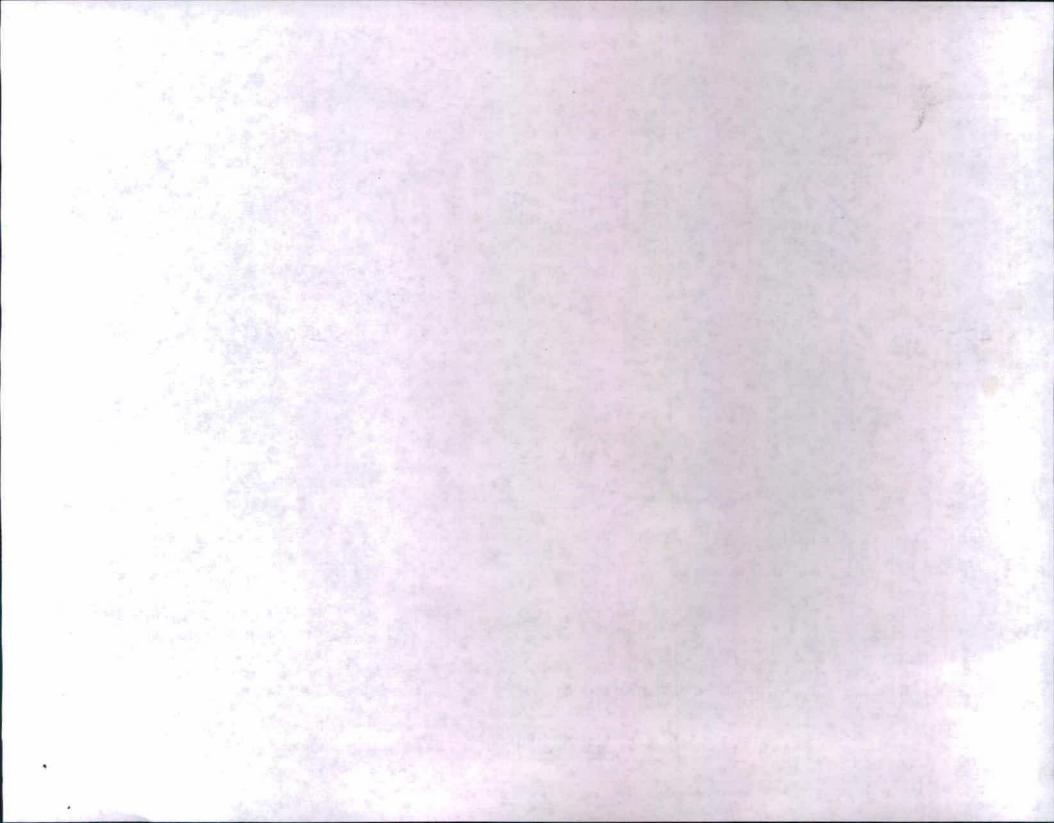
140

Quality Control

QC3- Inspect Part Finish

Memo

0.00



Work Order ID 62711

Wednesday, October 06, 2010 3:39:28 PM



Page 3

Item ID:

D4154-041

Accept

Setup Start



Revision ID:

Item Name:

Required Date: 10/15/2010

Wearplate Assembly

10/6/2010 Start Qty: 10.00

Cust Item ID: Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start Stop

Stop



OC:

Date:

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Date:

Plan

Code

Reject

Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

150

Small Fab Small Fab

Description

Operation

Reg'd Qty: 10.00

Memo 1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3

dwg D4154.

COATED inner surface to Rockguard 4715

Tool#

\$ 10/12/23

Accept

Qty

M116210 900 10/12/23

160

Quality Control

QC5- Inspect part completeness to step on W/O.

0.00

0.00 Sializ 23

(A)

170

Packaging

Packaging

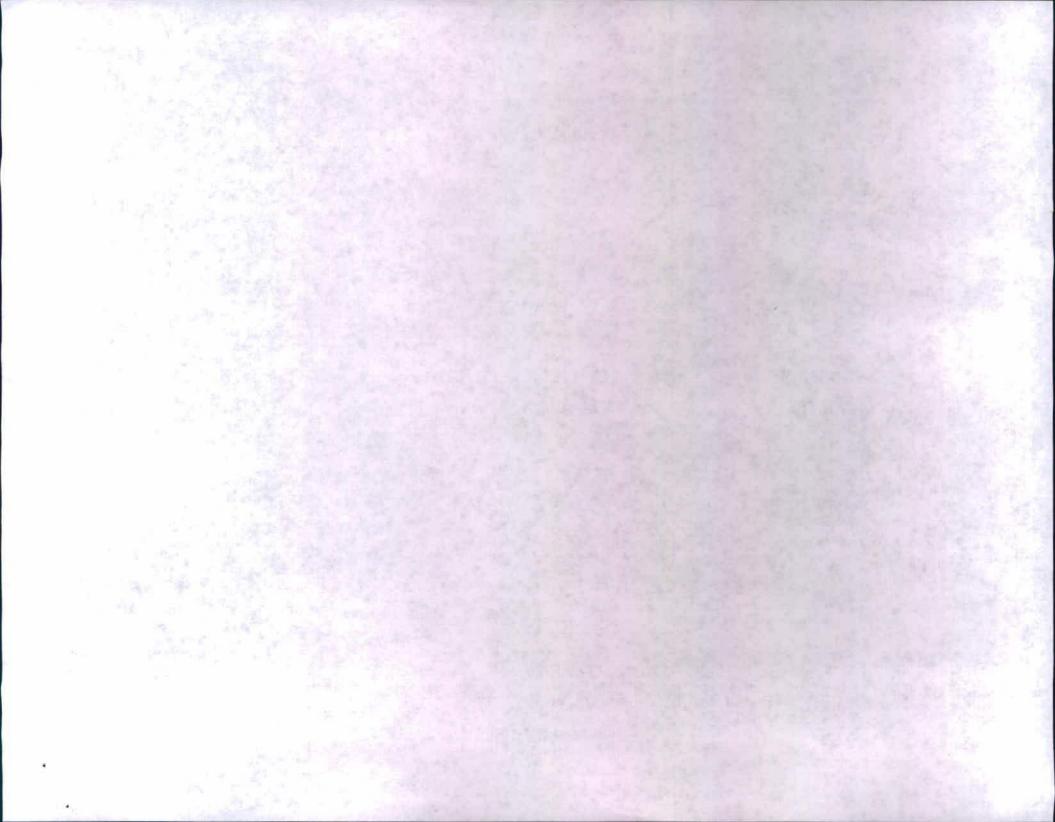
Identify as per dwg & Stock Location:

0.00

Memo

40/2/23(1)

Memo



Work Order ID 62711

Wednesday, October 06, 2010 3:39:28 PM

				IIII
Ш	Ш		Ш	

Item ID:

D4154-041

Accept

Setup Start

Revision ID:

Item Name:

Wearplate Assembly

Stop

Start Date:

10/6/2010

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID: Customer:

Reference:

Approvals:

Required Date: 10/15/2010

Process Plan:

Date:

Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ Run Hours

0.00

Tool ID

Tool# Plan Code

Accept Qty Qty

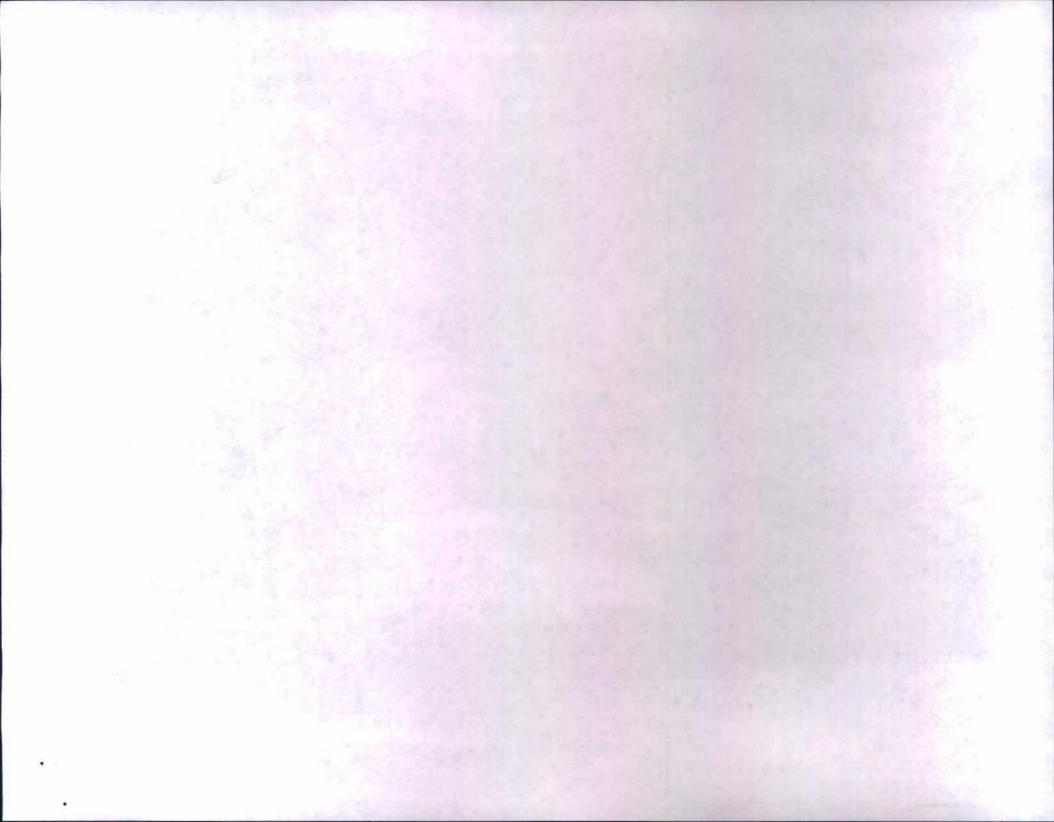
Reject Reject Number

Insp. Stamp

Quality Control

0.00

MF 10-12-23



Picklist Print

Wednesday, October 06, 2010 3:39:33 PM

Work Order ID: 62711

Parent Item:

D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 10/6/2010

Start Qty: 10.00

Required Date: 10/15/2010

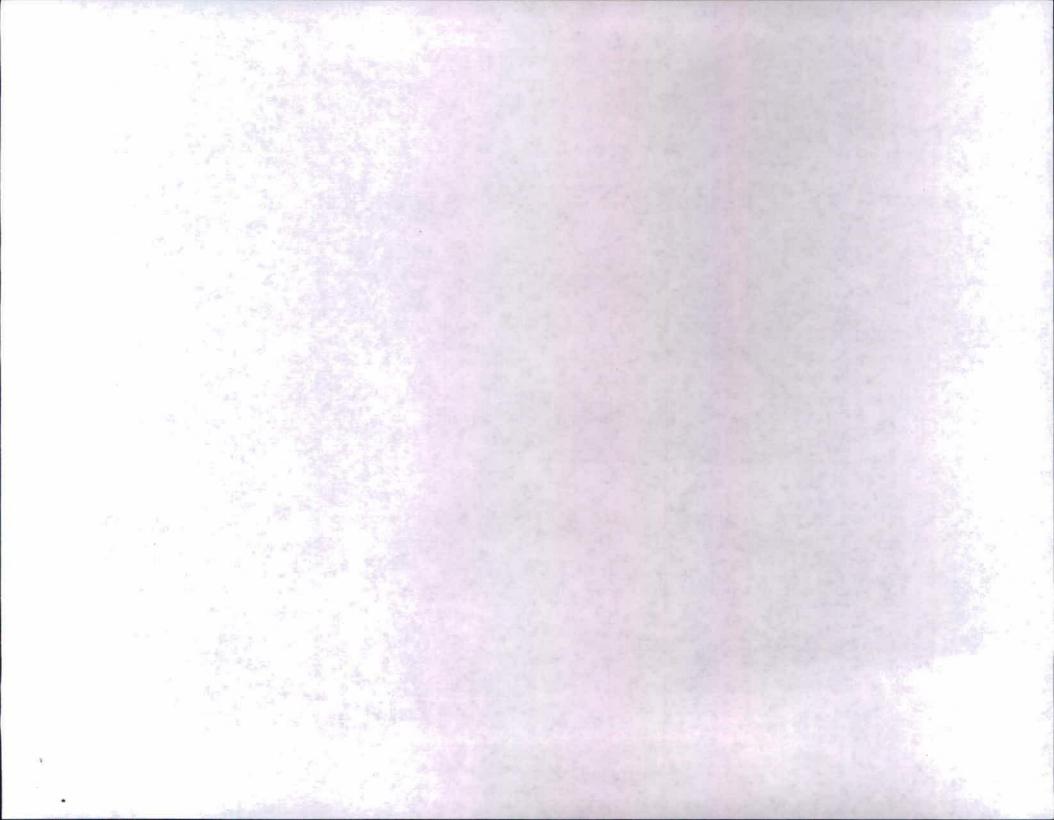
Page 1

Required Qty: 10.00

Comments:

IPP Rev:A 10.09.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D4154-1	III	Manufactured	No			100	Each	4.0000		10 EC	10-	11-230
	B6.	7708 ×	(<u>Location</u> WA	62199	Loc Q	4 4	Loc Code	_			
D4155-1		Manufactured	No		02177	100	Each	5.0000	1	10 EZ	10-12	1-33- 且
Ба				<u>Location</u> ST	60976 62198	Loc Q	5 2 3	Loc Code				
		22			62709		1			1		



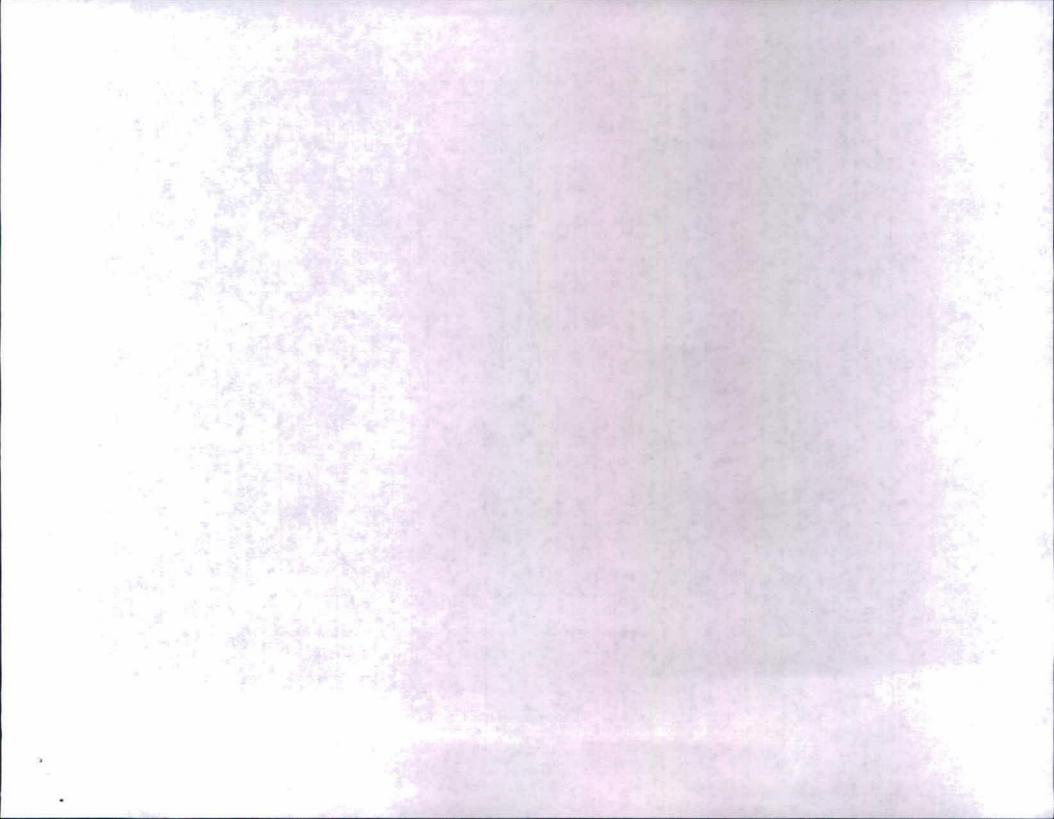
DART AEROSPACE LTD	Work Order:	13711
Description: Plate	Part Number:	D4154-1
Inspection Dwg: D4154 Rev: A		Page 1 of 1

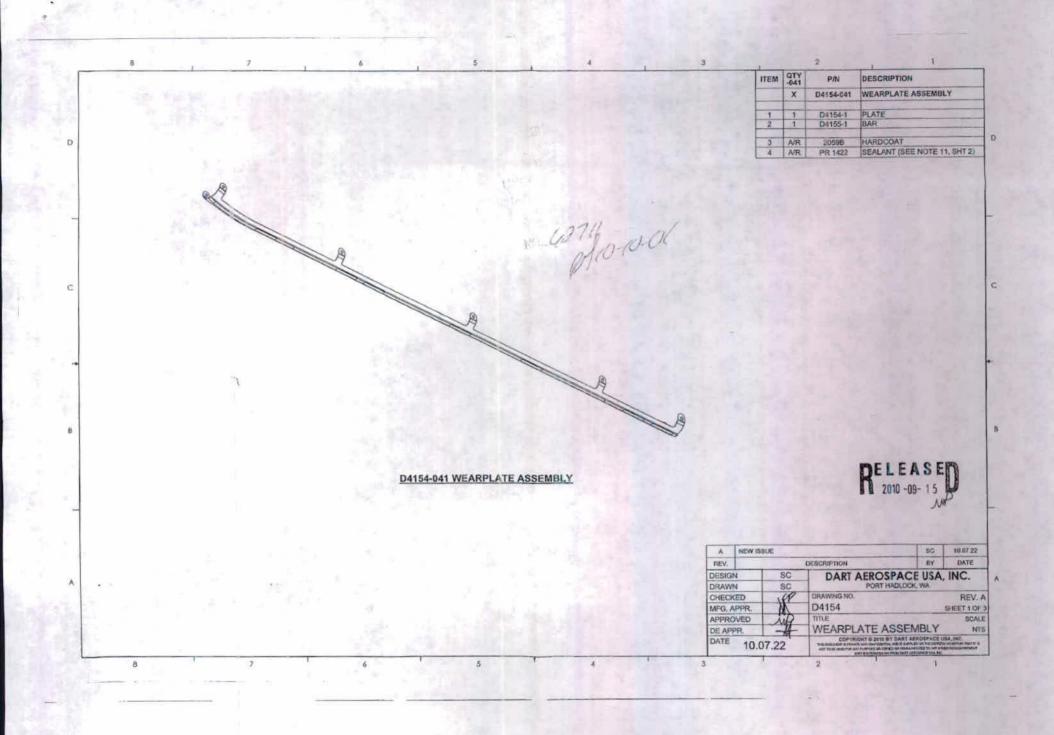
FIRST ARTICLE INSPECTION CHECKLIST

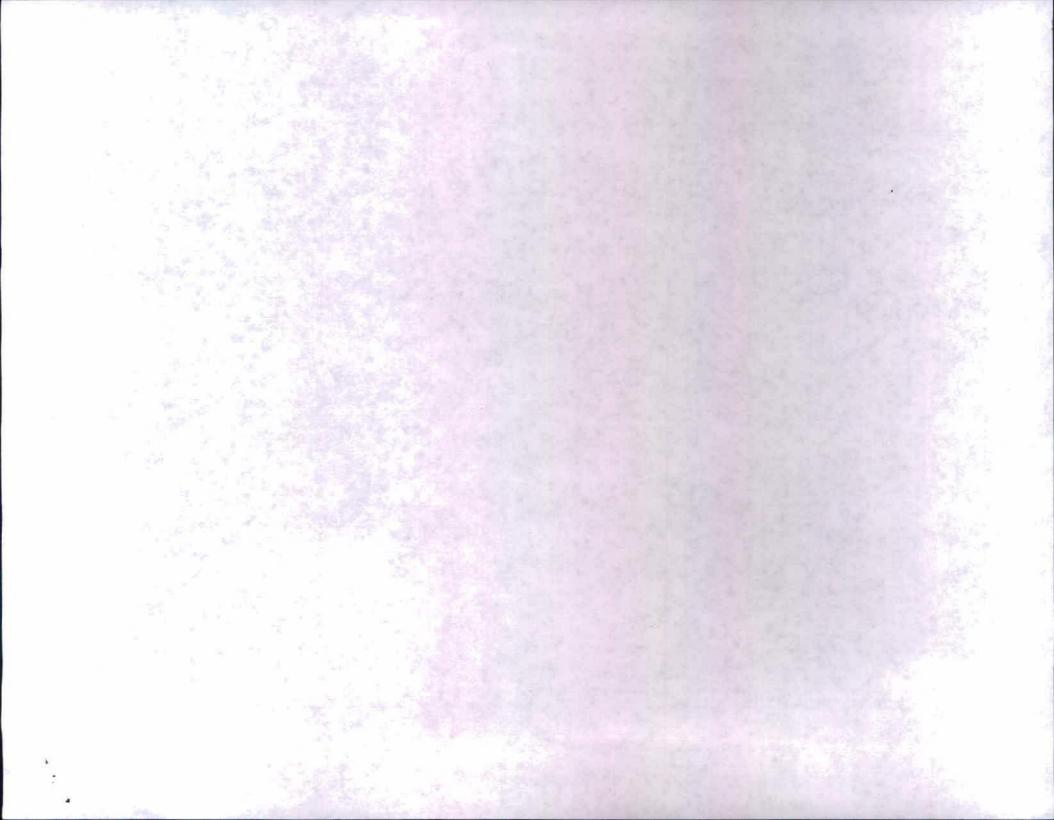
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001				47834	
Ø0.516	+0.008/-0.001				QERA L	
0.88	+/-0.030	777				1000
0.125	+/-0.010					138
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0.400	+/-0.010		TEL	The Party	1 75.15.50	
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91.50	+/-0.030					
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1.80	+/-0.030					
2.75	+/-0.030			5		
6.42	+/-0.030					
15.45	+/-0.030					
40.70	+/-0.030					The second second
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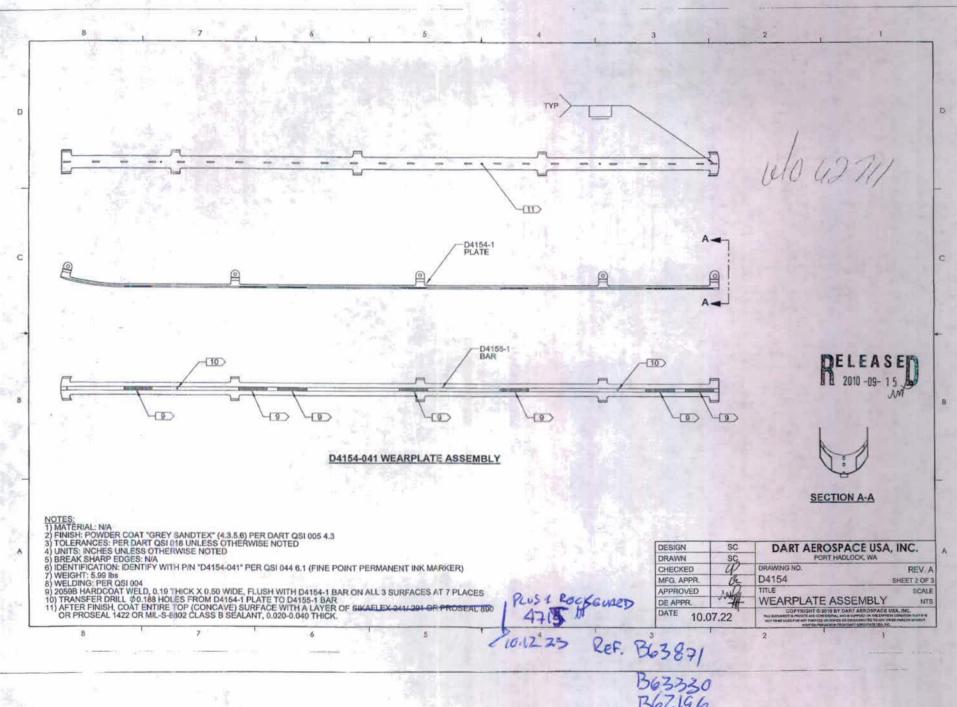
Measured by:	Audited by:	Preliminary Approval:	N/A
Date:	Date:	Date:	N/A

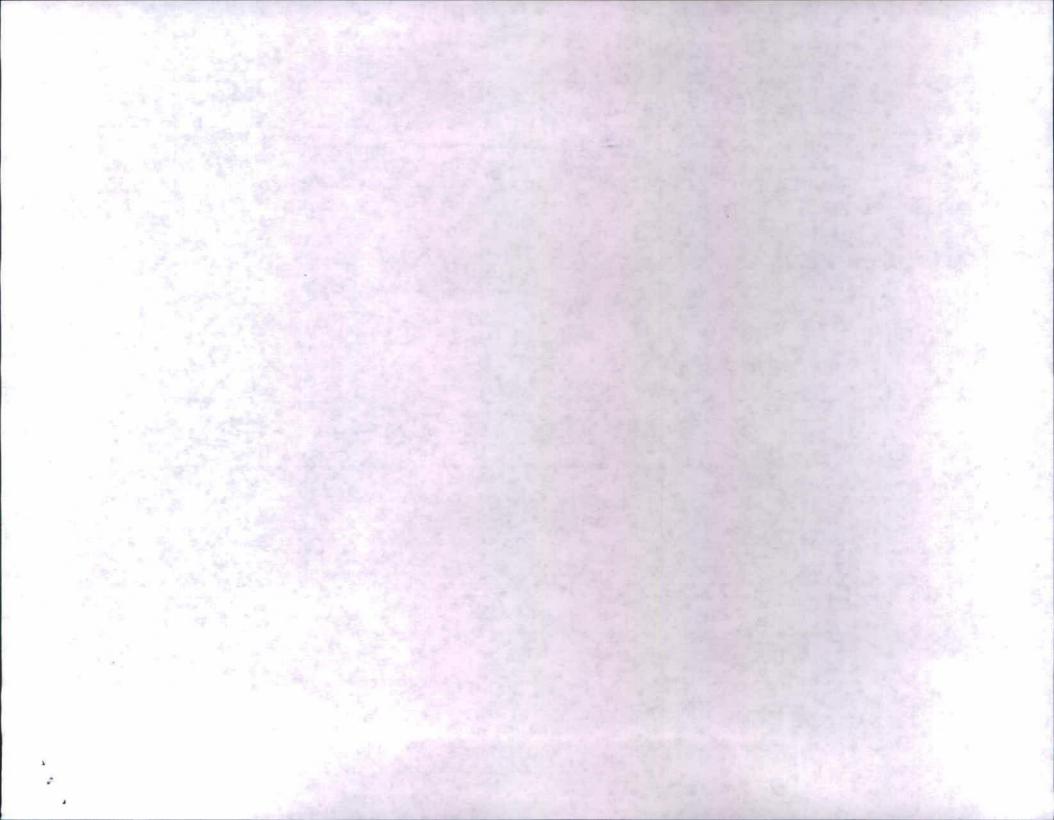
Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ 79	M











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